

**Work Order ID 70939**

Monday, June 20, 2011 8:27:02 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 6/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DC

DOCUMENT CONTROL

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod M117456/M112860 BE 11/06/20

4-Grind weld flush to cap on top surface only.

BE 11/06/20

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B ) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

3 DL 11/06/20

BB 11/06/27

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Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S Walebs

⑦

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H/Se

11.06.28.

125

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BE1/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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130

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.

cure time before cutting ☐Start Date: 11/06/28 Time: ☐ 3:30 ☐Finish Date: 11/06/29 Time: ☐ 3:00 ☐A/R ☐ Sikaflex-291 ☐ M116945Sikaflex expiry date: ☐ 12/01/15

Pl. 11/06/28

B 11/06/28

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 8 11/06/29

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



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150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod  
A/R ☐ Aluminum Rod ☒ *M12B60*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

4- Install nut plate as per dwg

*BE 11/07/04**BB 11/07/04**BE 11/07/05**BB 11/07/04*

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*8 11/07/06*

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Run Start



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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

54107/06

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 of BR 11-7-6

205



SprayPaint

Spray Painting

0.00

Memo

0.00

PRIME B 117319  
DELFLEET BLUE B 115985  
DELFLEET CLEAR B 117113 □

85 11-07-12

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Customer:

Reference:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

 11 07 13 0

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ 11/16/04Sikaflex expiry date: ☐ 11/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ 11/16/04Sikaflex expiry date: ☐ 11/08

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 111190631 0 11/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							
			Subtotal						
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
			Subtotal						
250  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D206-642-341 Location: _____ PPP Rev: _____	0.00 0.00							
			Total						

②

Paup/18①

W/O:		WORK ORDER CHANGES					
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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/14

MF  
11-07-14

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Work Order ID: 70939

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2620

Manufactured No

Each

12.0000

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

12

62684

1

68135

1

68136

10

D2647

Manufactured No

Each

25.0000

1



Cap

Location

Loc Qty

Loc Code

LG002

25

55352

25

D2649

Manufactured No

Each

111.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

99

68224

2

70394

97

LG001

12

65317

1

68507

11

D2654-5

Manufactured No

Each

3.0000

1



Web

Location

Loc Qty

Loc Code

LG

3

70229

3

W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

Each 30.0000

1



Nut Plate



1

*B 11/07/04*

Location

Loc Qty

Loc Code

ST020

30

55366

17

70088

13

MS27039C1-08 Purchased No

Each 804.0000

56



*56*

*11/07/13*

SCREW

Location

Loc Qty

Loc Code

FP-A

1

116022

1

ST293

803

116373

3

117291

800

ALS4-1032-130 Purchased No

220 Each 1,498.000

54



*54*

*11/07/13*

Insert

Location

Loc Qty

Loc Code

ST281

8

117331

8

ST282

1490

117717

1490

AN960C10L NAS1149C0332 Purchased No

220 Each 0.0000

54



*54*

*11/07/13*

washer

*1118306*

*(x54)*

*11/07/13*

AN960JD10L NAS1149D0332J Purchased No

220 Each 0.0000

2



*2*

*11/07/13*

Washer

*1117291*

*(x2)*

*11/07/13*

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Work Order ID: 70939

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220

Each

82.0000

1

1



Aft Cap



21 1107/13

Location

Loc Qty

Loc Code

FP004

62

68280

62

1370945

X1

FP006

20

62678

20

D2651-1

Manufactured No

220

Each

251.0000

14

14



Plug



21 1107/13

Location

Loc Qty

Loc Code

fpa

109

69018

109

1370942

X14

FP-A

142

57869

1

66445

10

67760

97

70827

30

70839

4

D2651-3

Manufactured No

220

Each

536.0000

14

14



O-Ring



21 1107/13

Location

Loc Qty

Loc Code

FP-A

536

61962

104

66956

432

X14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:27:16 AM

Work Order ID: 70939



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-11 Manufactured No

220 Each

8.0000

1

1



Wearshoe



ju 11/07/13

Location

Loc Qty

Loc Code

FP019

8

68362

8

xl

D3535-23 Manufactured No

220 Each

20.0000

1

1



Wearshoe



ju 11/07/13

Location

Loc Qty

Loc Code

FP021

20

66236

-1

67594

8

68342

13

xl

D3535-35 Manufactured No

220 Each

30.0000

1

1



Wearshoe



ju 11/07/13

Location

Loc Qty

Loc Code

FP018

10

65926

1

67598

1

68348

8

ST

20

69756

20

xl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Monday, June 20, 2011 8:27:16 AM

Work Order ID: 70939

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011



Required Date: 7/8/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-11	Manufactured	No	220	Each	13.0000	1	1
							<u>all 1107/13</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	13	
46649	1	
46715	4	
65574	8	<u>x1</u>

D3536-23	Manufactured	No	220	Each	39.0000	1	1
							<u>all 1107/13</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	39	
43406	1	
66560	12	<u>x1</u>
69902	26	

D3536-35	Manufactured	No	220	Each	27.0000	1	1
							<u>all 1107/13</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	27	
67599	1	
69755	26	<u>x1</u>

D3537-1	Manufactured	No	220	Each	10.0000	6	6
							<u>all 1107/13</u>
Wearpad							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	10	
69817	10	<u>1370686</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 20, 2011 8:27:16 AM

Work Order ID: 70939



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

220 Each

9.0000 1 1



Wearpad



Handwritten: 11/07/13

Location

Loc Qty

Loc Code

FP017

1

Handwritten: B70817

35697

1

Handwritten: 21

FP19

8

69292

8

MS27039-4-06 Purchased No

220 Each

57.0000 1 1



Screw



Handwritten: 11/07/13

Location

Loc Qty

Loc Code

FP-A

23

Handwritten: 115460

23

Handwritten: 21

ST292

34

115460

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70939

RELEASED  
08-07-23

11-06-20

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries





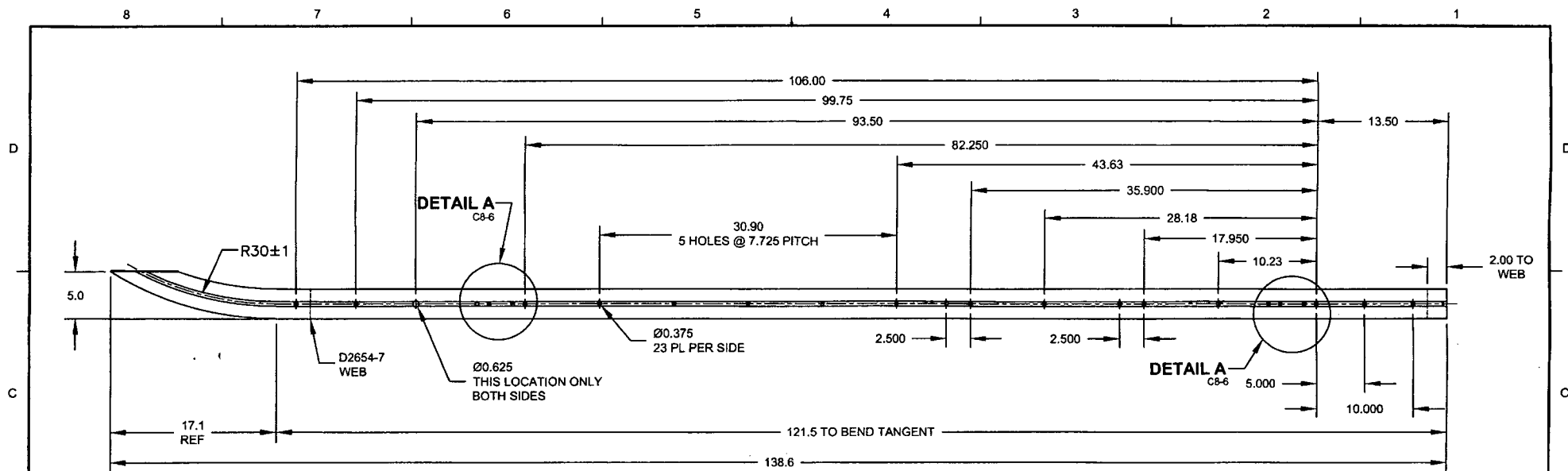
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

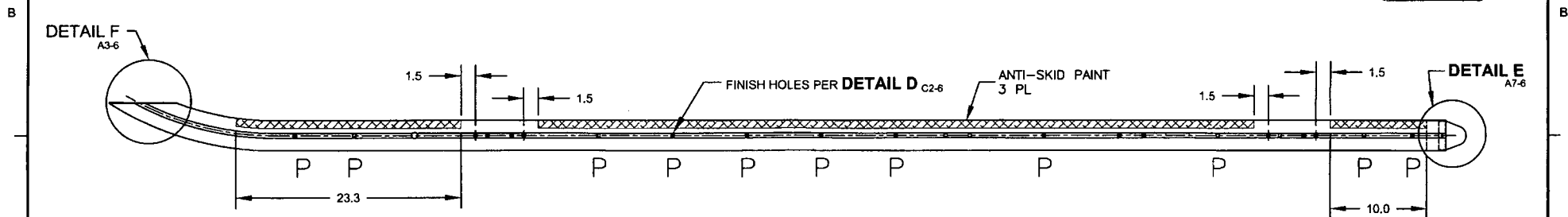
**NOTE:** Date & initial all entries



**D2650-7 BENDING/DRILL DETAIL**

W/ 70939

RELEASED  
08-07-22



**D2650-7 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	A/S	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

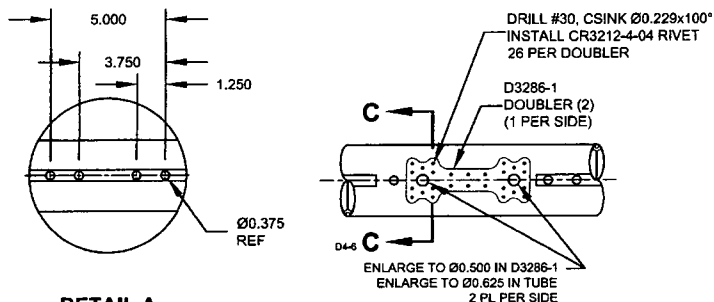
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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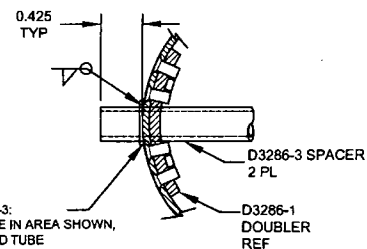
**DETAIL A**  
SCALE 2X

C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D8-5

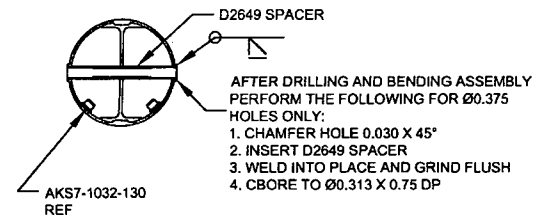
**DETAIL B**  
SCALE 2X

C3-2  
C3-3

**SECTION C-C** C7-6  
SCALE NONE



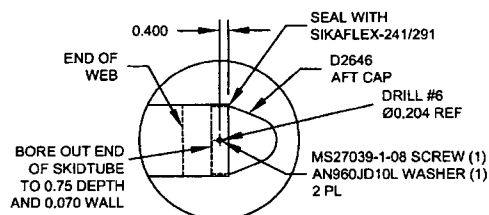
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X

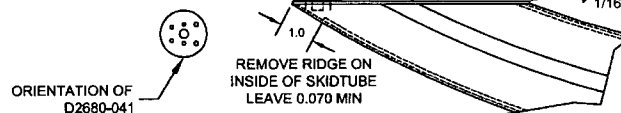
B4-2  
B4-3  
B4-4  
B4-5

*u/b 70939*



**DETAIL E**  
SCALE 2X

B2-2  
B2-3  
B1-4  
B1-5



**DETAIL F**  
SCALE NONE

B6-2  
B6-3  
B6-4  
B6-5

**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
05-09-2013

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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NOTE: Date & initial all entries

255  
NO. ~~255~~

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 69953  
Part number: 3206-642-341  
Description: 206  
Welding Process: Tig ☒ Mig ☐  
Base material: \_\_\_\_\_  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pat Cunn Date of Test Coupon 11.06.14  
Welder Barclay Elliot Date of Test Coupon 11/06/14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld